

Page 1

August-29-14 7:25:19 AM

Reference:

Stop ***NR2***

| | | | |
|-----------------|---|------|---|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | |
| *120* | | | |
| QC | Memo | 0.00 | <u>20</u> <u>0</u> <u>14/09/03</u> |
| Quality Control | | | |

Work Order ID 123914

123914

Page 2

Item ID: D2616-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 8/29/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------------|--------------|---------------|---------------|------------------|-------------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | B.O 14/09/03 | | 20 | 0 | | DAS 08 9-89 |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 20 | | 7B1494 | |
| 150 *150* Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 128564. Memo Note:Mask large hole TEMPERATURE: 320° FINISH TIME: 9:25 OVEN 9:55 | 0.00 0.00 | | | | 20 | 0 | 14-9-4 | DAS 34 9-89 |

August-29-14 7:25:19 AM

Item ID: D2616-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Mounting Lug

Stop *NS2*

Start Date: 8/29/14 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 9/05/14 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

190

Identify as per dwg & Stock Location: S52 0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

DAS
28
9-89

mf
14-9-11

Picklist Print

August-29-14 7:25:18 AM

Page 1

Work Order ID: 123914

123914

Parent Item: D2616-2

D2616-2

Parent Item Name: Mounting Lug

Start Date: 8/29/14

Required Date: 9/05/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:C00.06.22Removed P/O for powder coatEC
IPP Rev:D 08-01-07 rev E as per dwg ECN1069 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|--|------|---------|-----------|----|--|-------------|--|
| D2611 | | Manufactured | No | | | | Each | 28.0000 | | 20 | | | |
| *D2611* | | | | | | | | | ** | | | FF 14-09-10 | |
| Bearing | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|----|--|
| ST008A | 28 | |
| 108514 | 8 | |
| 121166 | 20 | |

M6061T6B1.000X02.00
0

Purchased No

f 8.4625

4

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|---------|--------|--|
| MAT002 | 8.4625 | |
| M128866 | 6.0125 | |
| M129167 | 2.45 | |

5.5

MH
14/08/31

| | | |
|---|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 123904 |
| Description: Mounting Lug | | Part Number: D2616-2 |
| Inspection Dwg: D2616 Rev: D3 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

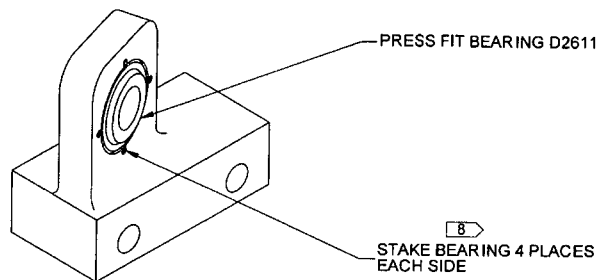
☒ **First Article**

 ☐ **Prototype**

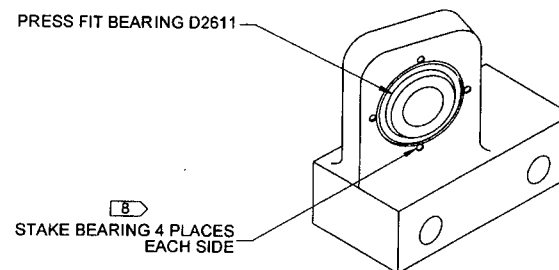
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|--------------|
| 0.250 | +/-0.010 | 0,248 | ✓ | | MJP-04 | vern |
| 1.250 | +/-0.010 | 1,249 | ✓ | | ... | ... |
| 0.375 | +/-0.010 | 0,374 | ✓ | | | |
| 0.625 | +/-0.010 | 0,626 | ✓ | | | |
| Ø0.257 | +0.006/-0.001 | 0,258 | ✓ | | | |
| 1.000 | +/-0.010 | 0,998 | ✓ | | | |
| 2.000 | +/-0.010 | 2,002 | ✓ | | | |
| 1.125 | +/-0.010 | 1,125 | ✓ | | | |
| 0.313 | +/-0.010 | 0,313 | ✓ | | ▽ | ▽ |
| 17° | +/-0.5° | 17° | ✓ | | MJP-06 | SQUARES |
| 1.259 | +/-0.010 | 1,254 | ✓ | | 31006 | Hight gauge |
| Ø0.625 | +0.008/-0.001 | 0,624 | ✓ | | MJP-04 | vern |
| R0.250 | +/-0.010 | 0,250 | ✓ | | — | Radius gauge |
| R0.063 | +/-0.010 | 0,063 | ✓ | | ... | ... |
| Ø0.8115- Ø0.8120 | N/A | 0,8115 | ✓ | | — | gauge pin |
| | | | | | | |
| | | | | | | |
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|--|--|----------------------------|-----|
| Measured by: <i>[Signature]</i> | Audited by: B.A. DAS 08 9-89 | Prototype Approval: | N/A |
| Date: 14/09/03 | Date: 14/09/03 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------------------|--------------------|
| A | 06.09.19 | New Issue | KJ/JLM <i>[Signature]</i> | <i>[Signature]</i> |



D2616-1 FWD MOUNT LUG



D2616-2 FWD MOUNT LUG

| QTY -1 | QTY -2 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-------------|---------------|
| X | | D2616-1 | FWD MOUNT LUG |
| | X | D2616-2 | FWD MOUNT LUG |
| 1 | 1 | D2611 | BEARING |
| 1 | | D2616-1A | LUG |
| | 1 | D2616-2A | LUG |

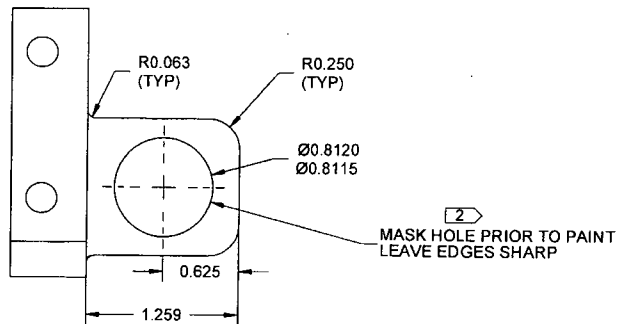
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2616-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) D2611 BEARING MUST BE STAKED TO PREVENT TRANSLATION BUT TO ALLOW ROTATION USING DT8019. TOUCH UP PAINT AFTER STAKING.

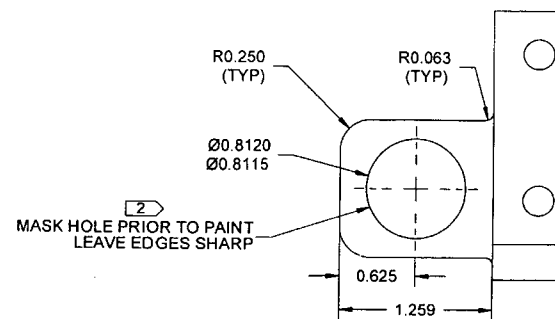
also 123914

RELEASED
07.12.11

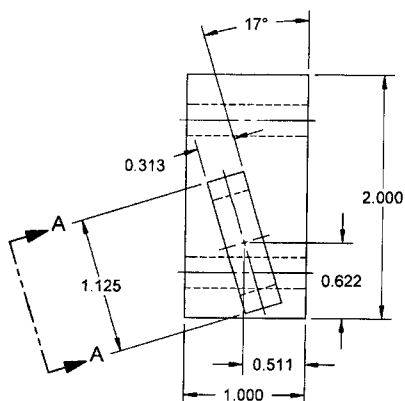
| E | UPDATE DWG. SHOW 4 STAKES INSTEAD OF 8 INCORPORATE HAND CHANGES | DC | 07.11.22 |
|------------|--|---|--------------|
| D | D2611 WAS CBA-6-B2 | KE | 97.07.31 |
| C | REMOVE D2616-3 | BW | 97.06.04 |
| B | RE-DESIGN | KE | 97.05.06 |
| A | ORIGINAL ISSUE | BW | 96.10.20 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | DC | | |
| CHECKED | KE | DRAWING NO. | REV. E |
| MFG. APPR. | KE | D2616 | SHEET 1 OF 2 |
| APPROVED | KE | TITLE | SCALE |
| DE APPR. | KE | FWD MOUNT LUG | 1:1 |
| DATE | 07.11.22 | <small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



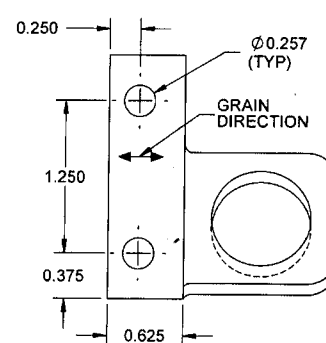
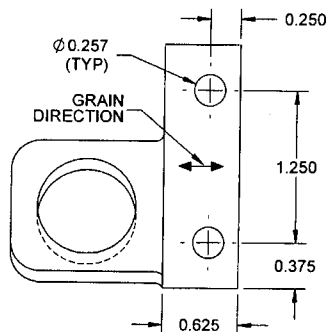
VIEW A-A



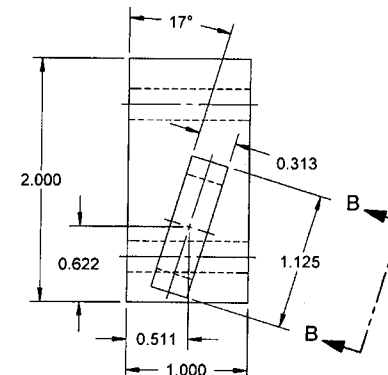
VIEW B-B



D2616-1A LUG



D2616-2A LUG



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK BEARING HOLE PRIOR TO PAINT
POWDER COAT GREY SANDTEX (4.3 5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.14 lbs

RELEASED
07.12.12

| | | | |
|--|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | JC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LE | DRAWING NO. | REV. E |
| MFG. APPR. | MA | D2616 | SHEET 2 OF 2 |
| APPROVED | MA | TITLE | SCALE |
| DE APPR. | MA | FWD MOUNT LUG | 1:1 |
| DATE | 07.11.22 | COPYRIGHT © 1996 BY DART AEROSPACE LTD | |
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